

Work Order ID 62169

Monday, September 20, 2010 10:15:47 AM



Page 1

Item ID:	D3684-045	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	LEG ASSEMBLY					
Start Date:	9/20/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	10/1/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-9-20	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3684	Rev D

100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

ES 10/09/27 ①

110	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684								
	2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684								
	ensure holes AN3C bolts are clear of sealant								

ES 10/09/27 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3684-045

Accept

Setup Start

Revision ID:

Stop

Item Name: LEG ASSEMBLY

Start Date: 9/20/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/1/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

8 10/09/27

FC

10/10/27 ①

10/09/27
ME
10-9-27

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Picklist Print

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Work Order ID: 62169

Parent Item: D3684-045

Parent Item Name: LEG ASSEMBLY



Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A Bolts		Purchased	No			110	Each	86.0000	2	2		9/20/09/27	
<div> <div>Location</div> <div>ST351</div> <div>112314</div> <div>114761</div> <div>115392</div> <div>115594</div> </div> <div> <div>Loc Qty</div> <div>86</div> <div>8</div> <div>11</div> <div>47</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>													
D3688-5 STUD		Manufactured	No			110	Each	6.0000	1	1		9/20/09/27	
<div> <div>Location</div> <div>ST081</div> <div>46054</div> </div> <div> <div>Loc Qty</div> <div>6</div> <div>6</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3689-1 SLEEVE		Manufactured	No			110	Each	13.0000	1	1		9/20/09/27	
<div> <div>Location</div> <div>ST082</div> <div>56335</div> <div>58634</div> </div> <div> <div>Loc Qty</div> <div>13</div> <div>1</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

BC2188 (1x)

W/O:		WORK ORDER CHANGES					
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Parent Item: D3684-045



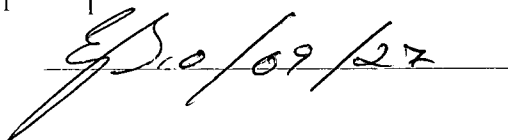


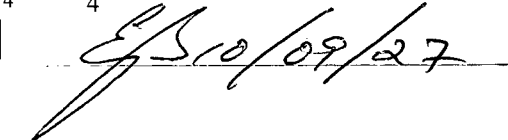


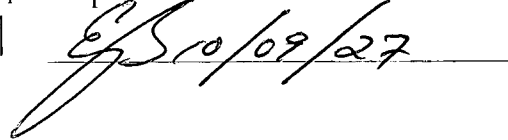


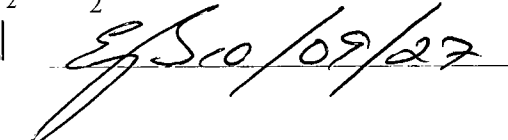
Parent Item Name: LEG ASSEMBLY

Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 1.00

Required Qty: 1.00

D3691-1	Manufactured	No	110	Each	15.0000	1	1
							
STUD							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST082	15			
			58631	15		1	
D3692-1	Manufactured	No	110	Each	349.0000	4	4
							
SPACER							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST082	349			
			51467	349		4	
D3693-1	Manufactured	No	110	Each	40.0000	1	1
							
Rod End Bearing							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST082	40			
			50734	40		1	
MS21043-3	Purchased	No	110	Each	2,643.000	2	2
							
Nut							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			FG	76			
			103691	76			
			ST301	2567			
			109147	4			
			111383	46			
			112314	2517		2	

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Parent Item: D3684-045



Parent Item Name: LEG ASSEMBLY

Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 1.00

Required Qty: 1.00

NAS509-12C

Purchased

No

110

Each

46.0000

1

1



Nuts



ES 10/09/27

Location

Loc Qty

Loc Code

ST280

46

112453

46

NAS509L12C

Purchased

No

110

Each

51.0000

1

1



Nuts



ES 10/09/27

Location

Loc Qty

Loc Code

ST280

51

112314

41

112828

10

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Shop Packet Print

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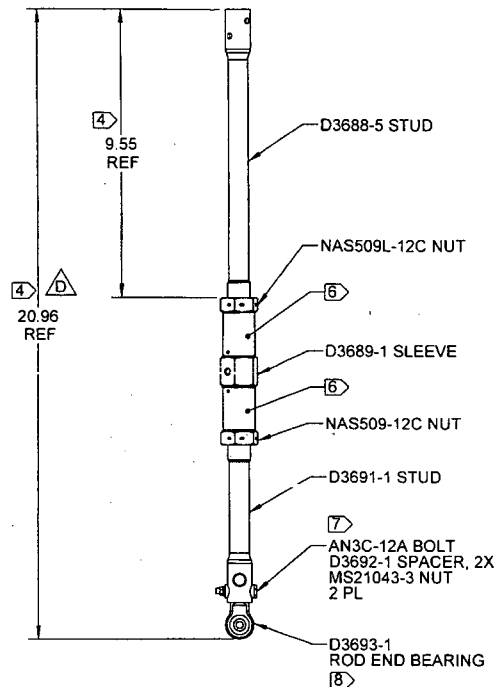
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT







D3684-045 INBOARD LEG ASSEMBLY



RELEASED
2010-03-15

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3684	REV. I
MFG. APPR.		SHEET 3 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	
DATE	10.03.03	NTS	
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